

Date: Friday, 27/02/2009 10:36:13 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : MOUNTING LUG
<b>Job Number</b> : 46112	
<b>Estimate Number</b> : 13266	
<b>P.O. Number</b> :	<b>Part Number</b> : D37073
<b>This Issue</b> : 27/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3707 REV.B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 44727	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 06/03/2009 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>J.D. 09.02.27</u>	
<b>Comment</b> : Est Rev:A New Issue 08-04-16 JLM Verified By:EC Est Rev:B 09-02-20 rev.b as per dwg DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MDELRLNB1250X2500	Delrin Bar 1.250"X 2.500"
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**Comment:** Qty.: 0.2363 Ft(s)/Unit Total : 2.3625 Ft(s)  
 Delrin Bar 1.250"X 2.500"  
 BATCH: 0107758

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
 Cut blank 2.700" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1 HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA738 Rev: A & Dwg D3707 Rev: B

2-Deburr per dwg D3707

J.F. / 09/03/02

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/03/03

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

88 09/03/03 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 27/02/2009 10:36:14 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 46112

Part Number: D37073

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(12x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *15*

*9/3/3*

*500*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/03/04*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 09-03-03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46112
<b>Description:</b> Mounting Lug		<b>Part Number:</b> D3707-3
<b>Inspection Dwg:</b> D3707 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

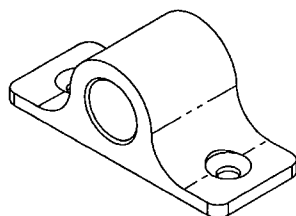
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50"	±.030	2.499"	✓			
1.750"	±.010	1.752"	✓			
R0.13"	±.030	R0.125"	✓			<del>2 PL</del>
.38"	±.030	.375"	✓			
.500"	±.010	.497"	✓			
1.00"	±.030	1.001"	✓			
Ø 0.201"	±.005	Ø.200"	✓			2 PL
* CSK Ø.385x100°	±.010	Ø.385x100°	✓			2 PL
.03"	±.030	.040"	✓			
* Ø 0.563	±.005	Ø.562"	✓			
R0.06"	±.030	R.060"	✓			
2.063"	±.010	2.063"	✓			
.98"	±.030	.975"	✓			
.500"	±.010	.496"	✓			
R0.48"	±.030	R0.477"	✓			
1.250"	±.010	1.249"	✓			
.125"	±.010	.125"	✓			
R0.38"	±.030	R.380"	✓			

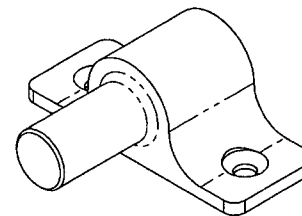
<b>Measured by:</b> J.F.	<b>Audited by:</b> SP	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/03/03	<b>Date:</b> 09/03/03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

*[Signature]*



**D3707-1 MOUNTING LUG**



**D3707-3 MOUNTING LUG**

**RELEASED**  
08/04/05 MB

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WORK ORDER  
NO. 41012

**NOTES:**

- 1) MATERIAL: BLACK ACETRON GP ACETAL  
(REF DART SPEC M-DELIN-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: SCRIBE WITH DART P/N "D3707-X" USING VIBRATING STYLUS
- 7) WEIGHT: D3707-1 = 0.04 lbs APPROX  
D3707-3 = 0.07 lbs APPROX

B	UPDATED NOTE 1 (ZN A8-1)	MB	08.08.22
A	NEW ISSUE	MB	08.04.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.22		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3707</b>	REV. B
TITLE <b>MOUNTING LUG</b>	SCALE NTS
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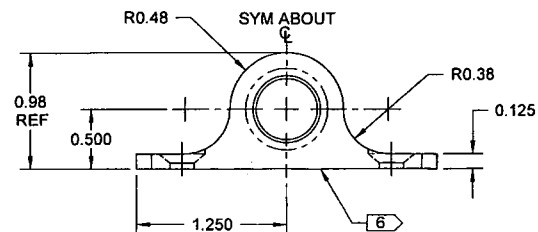
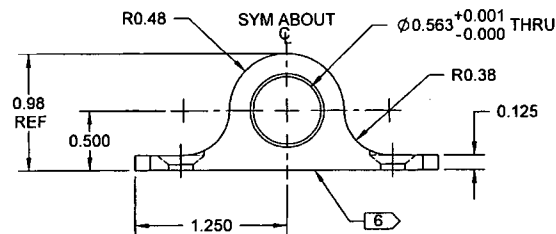
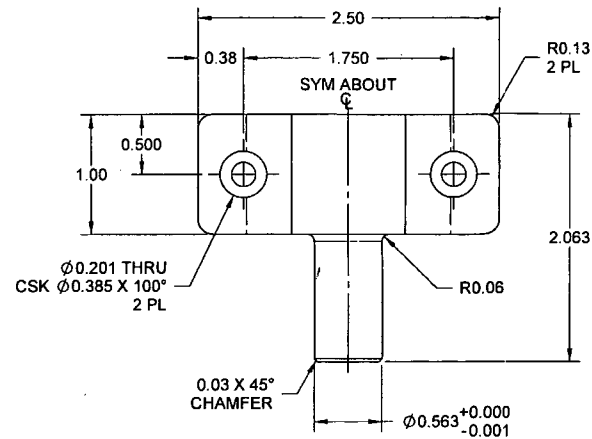
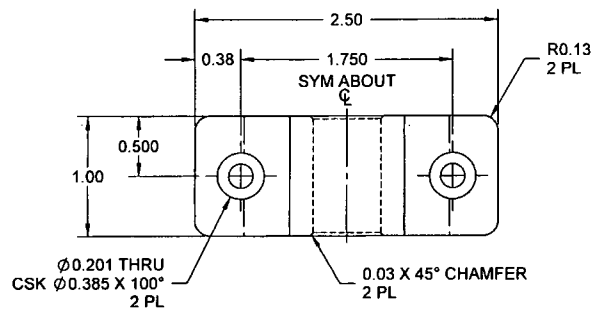
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**NOTE:** Date & initial all entries



**D3707-1 MOUNTING LUG**

**D3707-3 MOUNTING LUG**

**RELEASED**  
5/2/05

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3707</b>	REV. B
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING LUG</b>	NTS
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